

Work Order ID 94414

December-17-12 3:10:17 PM

94414

Page 1

Item ID: D2364

Accepted

N900040100

Setup

p Start

NS1

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 17/12/2012 **Start Qty:** 10.0

* 10 *

Cust Item ID

Customer

Required Date: 02/01/2013 Req'd Qty: 10.0

10

Reference:

Reference:

Approvals: **Process Plan:**

Date: 12-12-17 Tooling

Date:

Run Start

NR1

OC;

Date:

SPC (Y/N)

Date:

Stop

NR2

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____		NCR No. _____									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

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Page 2

Item ID: D2364

Accept

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 17/12/2012 Start Qty: 10.00

10

Required Date: 02/01/2013 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID

130

130

Small Fab

Operation
Description

Small Fab

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

1- counter sink holes as per dwg D23642- deburr if necessary

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
15
9-69

14

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

13.1.15

14

16

13

4

1

1-21

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order ID 94414

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Item ID: D2364

Accept

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 17/12/2012 Start Qty: 10.00

10

Required Date: 02/01/2013 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Powdercoat

Powder Coating

Black Sandtex(Ref 4.3.5.7) per QSI005 4.3

M123480

0.00

14. 12/13-124.

Memo

0.00

START TIME:

2:20

OVEN TEMPERATURE:

320° FINISH TIME:

250

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

OAS
15
89

0.00 13 128

14

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: ST

0.00

220A

Memo

0.00

12/13-01/28 (14)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain	General			Ovalized	Pressure/Forced		
Centre Not Concentric to O/S	Bend	General			Hardware	General			Over/Under tolerance	Temperature/Cure	
Cracks	BOM/Route	General			Inspection Incomplete	General			Part Incorrect	Weld	
Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear	General			Part Lost/Missing	Wrong Stock Pulled	
Cuffs	Burrs	General			Maintenance	General			Part Moved		
Heat Treat	Contamination	General			Mislabeled	General			Positioned Wrong		
Inspection Strip in Tube	Countersink	General			Misread	General			Power Loss/Surge		
Ripples in Bend	Cut Too Short	General			Offset	General					
Torque Waves in Extrusion	Drill Holes	General			Out of Calibration	General					
Turning Sequence	Drawing	General			Out of Sequence	General					
Wave/Twist in Tube	Finish	General			Outside Dimensions	General					
	Folio	General				General					

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Page 4

Item ID: D2364

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Stop

NS2

Start Date: 17/12/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/01/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

1Q1

QC

Quality Control

13/1/2012

PLB-012

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>						
	Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>		Other <input type="checkbox"/>						
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

Picklist Print

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Page 1

Work Order ID: 94414

94414

Parent Item: D2364

D2364

Parent Item Name: Deck Plate. Fwd 350 Litt

Start Date: 17/12/2012

Required Date: 02/01/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased		No		100	sf	233.8400	0.6469	6.809474	6.975	JM 1-6-13	

M2024T3S 063

Location	Loc Qty	Loc Code
MAT022	233.84	
119916	0.2	
121197	21.34	
123654	27.8	
123701	184.5	A3701

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>						
	Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>							
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>								
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>								

DART AEROSPACE LTD	Work Order:	94414
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.630"	-		V	Jkm01
Ø0.171	+0.005/-0.000	0.171"	-		V	
0.354	+/-0.010	0.357"	-		V	
11.242	+/-0.010	11.250"	-		V	
3.031	+/-0.010	3.035"	-		V	Prod w/02
1.903	+/-0.010	1.905"	-		V	
1.128	+/-0.010	1.132"	-		V	
0.354	+/-0.010	0.359"	-		V	
1.340	+/-0.005	1.343"	-		V	
2.326	+/-0.010	2.330"	-		V	
3.312	+/-0.010	3.317"	-		V	
4.298	+/-0.010	4.295"	-		V	
5.284	+/-0.010	5.290"	-		V	
6.151	+/-0.010	6.155"	-		V	
6.270	+/-0.010	6.276"	-		V	
0.354	+/-0.010	0.359"	-		V	
3.031	+/-0.010	3.031"	-		V	
Ø0.656	+0.005/-0.000	0.656"	-		V	
5.003	+/-0.010	5.007"	-		V	
4.605	+/-0.010	4.610"	-		V	
1.776	+/-0.010	1.781"	-		V	
0.980	+/-0.010	0.990"	-		V	
4.487	+/-0.010	4.491"	-		V	
7.192	+/-0.010	7.197"	-		V	
7.567	+/-0.010	7.569"	-		V	
7.942	+/-0.010	7.943"	-		V	
Ø0.191	+0.005/-0.000	0.191"	-		V	
Ø0.197	+0.005/-0.000	0.197"	-		V	
11.145	+/-0.010	11.150"	-		V	
12.181	+/-0.010	12.187"	-		T	Jkm01c
11.378	+/-0.010	11.379"	-		V	
11.776	+/-0.010	11.779"	-		V	
12.173	+/-0.010	12.173"	-		T	
4.690	+/-0.010	4.697"	-		V	
0.250	+0.005/-0.000	0.253"	-		V	
3.141	+/-0.010	3.144"	✓		V	
0.171	+0.005/-0.000	0.173"	-		V	

Measured by:	JM	Audited by:	SM	Prototype Approval:	N/A
Date:	1-6-13	Date:	13-17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	DA

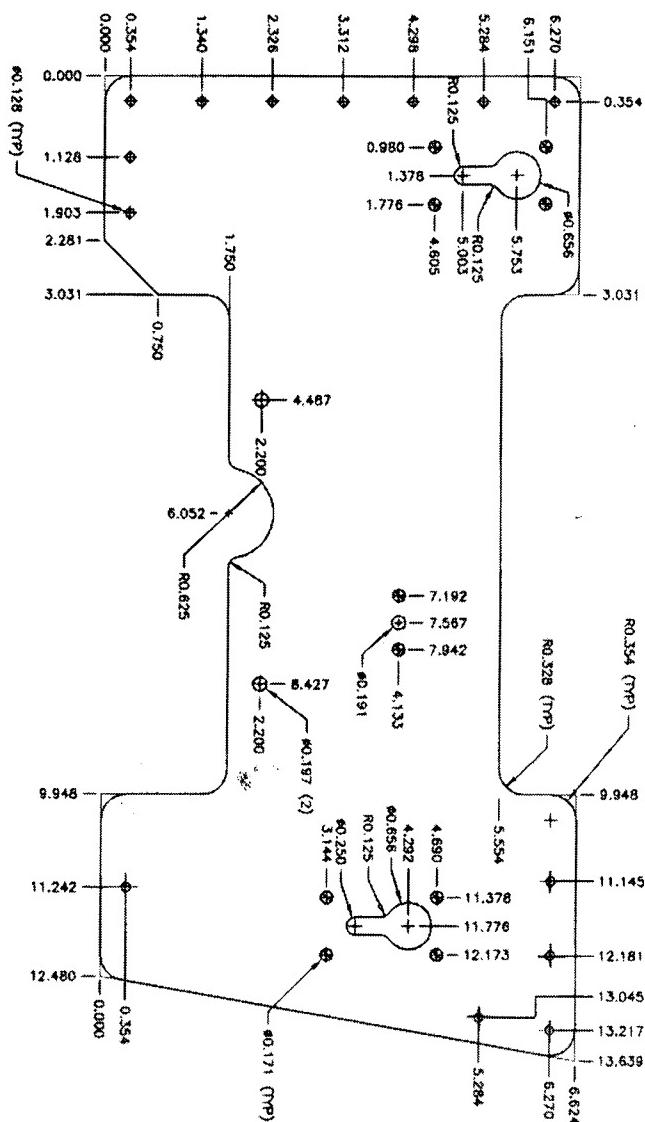
COUNTER SINK HOLES:
 C'SINK $\varnothing 0.225 \times 100'$ (UPDATED FROM 9 TO 14 HOLES FOR DS 97-03-01 TO CORRECT CAD ERROR)
 C'SINK $\varnothing 0.308 \times 100'$

94414 MUS
12-12-17



DART
DRAWING NO.
D2364

DESIGN	DRAWN BY	APPROVED	DRAWMNG NO.	DATE	TIME	LITTER DECK PLATE, 350	SCALE
REV. F	REVIEWED	CHIEF	D2364	98.06.19	95.02.09	MMOVED KEYWAY	0.191 WAS 0.197
SHEET 1 OF 1	95.03.06	95.10.06	GEOMETRY CHANGES	98.06.19	0.063-0.071 THICK	11.145	(TSR A371)
2-5	12.480	11.242	0.000	9.948	0.354	5.284	9.948



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED